

In claim 38, line 1, cancel "37" and insert -- 53 --

In claim 41, line 1, cancel "35" and insert -- 53 --.

Cancel claim 1, 27, 28 and 37, without prejudice and, in lieu thereof, insert the following claims 50-54:

50. A lined multi-branch fitting comprising:

a one-piece multi-branch hollow liner having a plurality of intersecting non-metallic hollow cylindrical branches in fluid communication with each other;

a plurality of individual confronting metal housing members, assembled over and snugly receiving said non-metallic branches, having confronting terminal ends disposed in confronting relation with each other; and

a fillet weld bead integrally coupling said terminal ends of said confronting terminal ends of said metal housing members together in sealed relation with each other.

51. The lined multi-branch fitting set forth in claim 50 wherein one of said confronting terminal ends includes an insulating projection on one of said metal housing members and the other of said confronting terminal ends includes a complementally formed recess defining an insulation barrier between said fillet weld bead and said liner.

52. The lined multi-branch fitting set forth in claim 50 wherein one of said confronting ends includes

a radially outer end portion having a first radially outer end face, and

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cont.

a radially inner end portion having a first radially inner end face relieved relative to said radially outer end face to define a radially inwardly opening, radially inner notch;

the other of said confronting ends including

a radially outer end portion having a second radially outer end face, confronting but spaced from said first outer end face to define a weld channel there-between for receiving said fillet weld, and

a radially inner end portion received by said notch having a second radially inner end face projecting outwardly beyond said second radially outer face and disposed in abutting relation with said first radially inner end face.

*24* 53. A lined multi-branch fitting comprising:

a one-piece multi-branch non-metallic liner having a plurality of intersecting hollow cylindrical branches in fluid communication with each other;

a plurality of metal housing members assembled about said hollow branches including,

radially inner complementally formed, confronting terminal end portions disposed in abutting relation and snugly receiving said liner; and

radially outer portions having terminal end faces, one of said faces being recessed relative to the other terminal end face to provide a radially outwardly opening weld recess; and

an annular bead of weld metal received in said weld recess radially outwardly of said inner portions to secure said metal housing members together;

said radially inner portion of one of said metal housing members including a radially inwardly opening notch and the radially inner portion of the other of said metal housing members comprises a male strip projection complementally received by said notch; said one end face on said other metallic housing member being recessed to provide said radially outwardly opening weld recess.

54. A method of fabricating a lined, multi-branch fitting comprising the steps of:

selecting a one-piece multi-branch hollow non-metallic liner having a plurality of hollow, angularly offset cylindrical branches in fluid communication with each other;

assembling, in confronting relation about said branches of said liner, a plurality of confronting metal housing members having cylindrical portions receiving said branches and terminal end faces disposed in confronting relation with each other;

fillet welding said confronting housing members together by applying weld heat to said radially outer portion of said one metal housing member; and

insulating a portion of the liner adjacent a radially inner portion of one of said metal housing members from weld heat applied to said radially outer portion of said one metal housing member.